

Work Order ID 119917

119917

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May-29-14 2:57:29 PM

Item ID: D4624-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Plate

Start Date: 5/29/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4624	A

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D4624

Dwg Rev: 3

Prog Rev: 4

2-Deburr as required

① 17/06/02 DAS 20 9-89 /mm

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

① 17/06/02 DAS 20 9-89 /mm

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Item ID: D4624-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Plate

Start Date: 5/29/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

① 14-06-03

DAS
9
9-89

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

126 14-6-5

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

DAS
279-89
14/6/5

Picklist Print

May-29-14 2:57:28 PM

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Work Order ID: 119917

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Parent Item: D4624-1

D4624-1

Parent Item Name: Mounting Plate

Start Date: 5/29/14

Required Date: 5/30/14

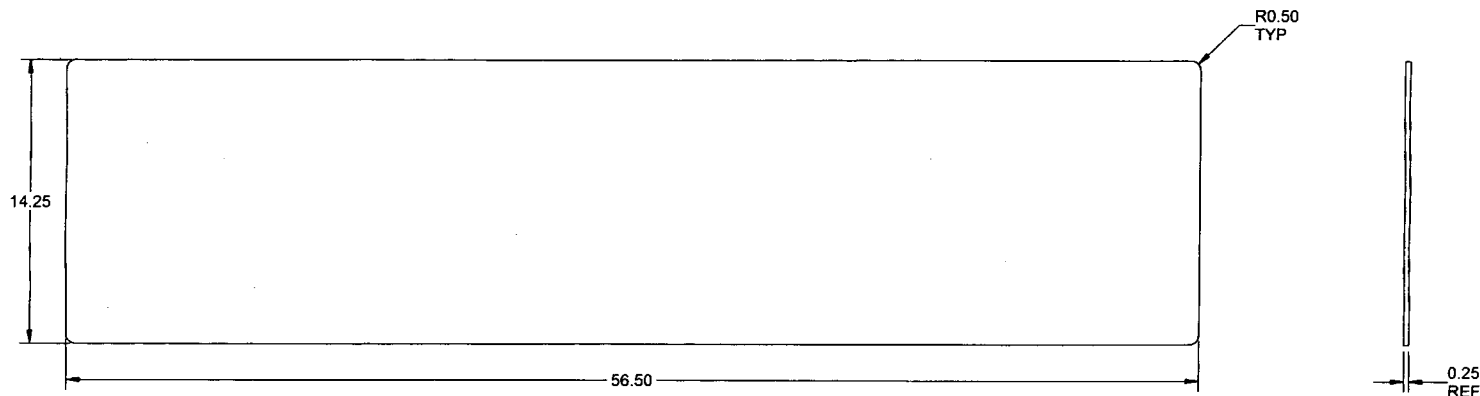
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-27 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.250		Purchased	No			100	sf	0.0000	5.9	7			
M6061T6S 250									**	6		mm	14/06/02
6061T6 SHEET .250													

m129344



D4624-1 MOUNTING PLATE

no 119917

2012-04-04

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4624-1" AND B/N "BXXXXX" PER DART QSI.044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 19.60 lbs

A	NEW ISSUE	MB	12.03.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4624	REV. A
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